

Work Order ID 130137

Tuesday, February 24, 2015 1:01:15 PM

130137

Page 1

Item ID: D2991-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Side Door

Start Date: 2/24/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/24/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: **ML5**Date: **15-02-24** Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2991

E

110

0.00

110

Purchasing

Purchasing

0.00

Purchasing

Memo

Issue P/O: **27567**

Description: D2991-2 side door

Supplier: Delastek

Doubler batch:

Ship to Delastek (1) D0589-XXX label

Batch: **130137**

Certificate of Conformity and process sheet from Delastek

Ship to delastek: Qty 2 D2992-1 **130172****CL 15/02/25 ①**

120

Receive & Inspect for Damage & Mat'l Certs

0.00

120

Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

1X SP 15-06-22

Work Order ID 130137

130137

Page 2

Tuesday, February 24, 2015 1:01:15 PM

Item ID: D2991-2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Side Door

Start Date: 2/24/2015 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 2/24/2015 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling:

Date:

Run Start *NR1*

QC: Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 QC6- Inspect dimensions to drawing 0.00

130

QC Memo 0.00
Quality Control Ensure Material certification comply to Dwg D2991

DAS
9
9-89

140 Identify as per dwg & Stock Location: JK 0.00

140

Packaging Memo w/o 130136 0.00
Packaging

Whe
16/04/13

150 QC21- Final Inspection - Work Order Release 0.00

150

QC Memo 0.00
Quality Control

MCS APR 13 2016

16-4-13

Picklist Print

Tuesday, February 24, 2015 1:01:19 PM

Page 1

Work Order ID: 130137

130137

Parent Item: D2991-2

D2991-2

Parent Item Name: Side Door

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev. A 06.02.16 new issue (was done on D350-589-041) EC
IPP Rev:B 08-02-20 ECN 1096 DD verified by:EC IPP Rev:C
10.10.13 AS PER DWG REV.E DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2991-2P

Purchased

No

110

Each

0.0000

1

1

D2991-2P

**

Side Door

1 X SP 15-06-22

D2992-1

B130137

X2 + 2 = 4 c215/03/27

D2991-1/-2/-3 SIDE DOOR

NOTES

1) MATERIALS: RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")

2) FINISH: FINISH INSIDE WITH DUPONT HIGHBUILD PRIMER GREY #1104S OR #1144S

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 9 lbs TYP

8) USE MOLD DT8626 FOR D2991-1 SIDE DOOR
USE MOLD DT8627 FOR D2991-2 SIDE DOOR
USE MOLD DT8626 FOR D2991-3 SIDE DOOR (TRIM PER DT8631)

9) ROUTER FOAM CORE USING: DT8628 FOR D2991-1 SIDE DOOR
DT8629 FOR D2991-2 SIDE DOOR
DT8630 FOR D2991-3 SIDE DOOR

10) LAYUP PER QSI 006 AND AS FOLLOWS:

MAIN LAYUP: WHITE GLOSS GELCOAT #GEL 944W005
9 OZ SATIN
9 OZ SATIN
FOAM
FOAM STRIP
9 OZ SATIN
12 OZ UNIDIRECTIONAL (4.5" WIDE, 2 EDGES SHOWN)
9 OZ SATIN
RESIN (35-45% BY WEIGHT)
PEEL PLY

11) BOND FOAM CORE USING POLYBOND B46F

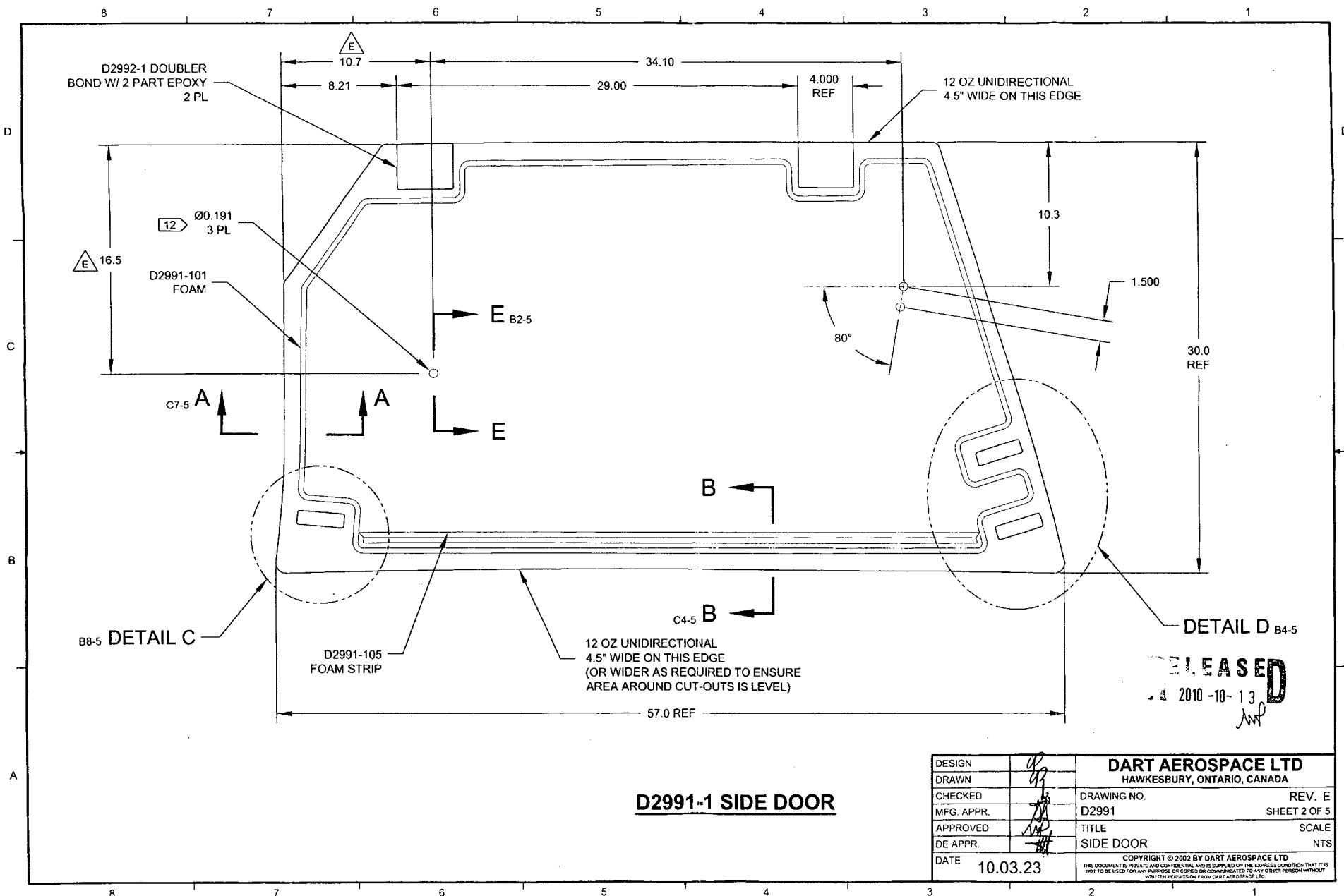
12) DRILL Ø0.38 HOLE. REMOVE THE FOAM INNER LAYER 0.25 AROUND THE HOLE BETWEEN THE INNER AND OUTER SKINS. APPLY TAPE OR AN EQUIVALENT BACKER TO THE INNER SIDE OF THE HOLES TO PREVENT EPOXY FILLER FROM GOING THROUGH. FILL THE CAVITY BETWEEN THE SKINS COMPLETELY WITH HYSOL 934NA MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1, OR HYSOL 956A/B MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1, OR METALSET A4, OR MAGNABOND 6398. ALLOW THE MATERIAL TO CURE. DRILL Ø0.191 THROUGH, 3 PLACES PER DOOR. SEE SECTION E-E.

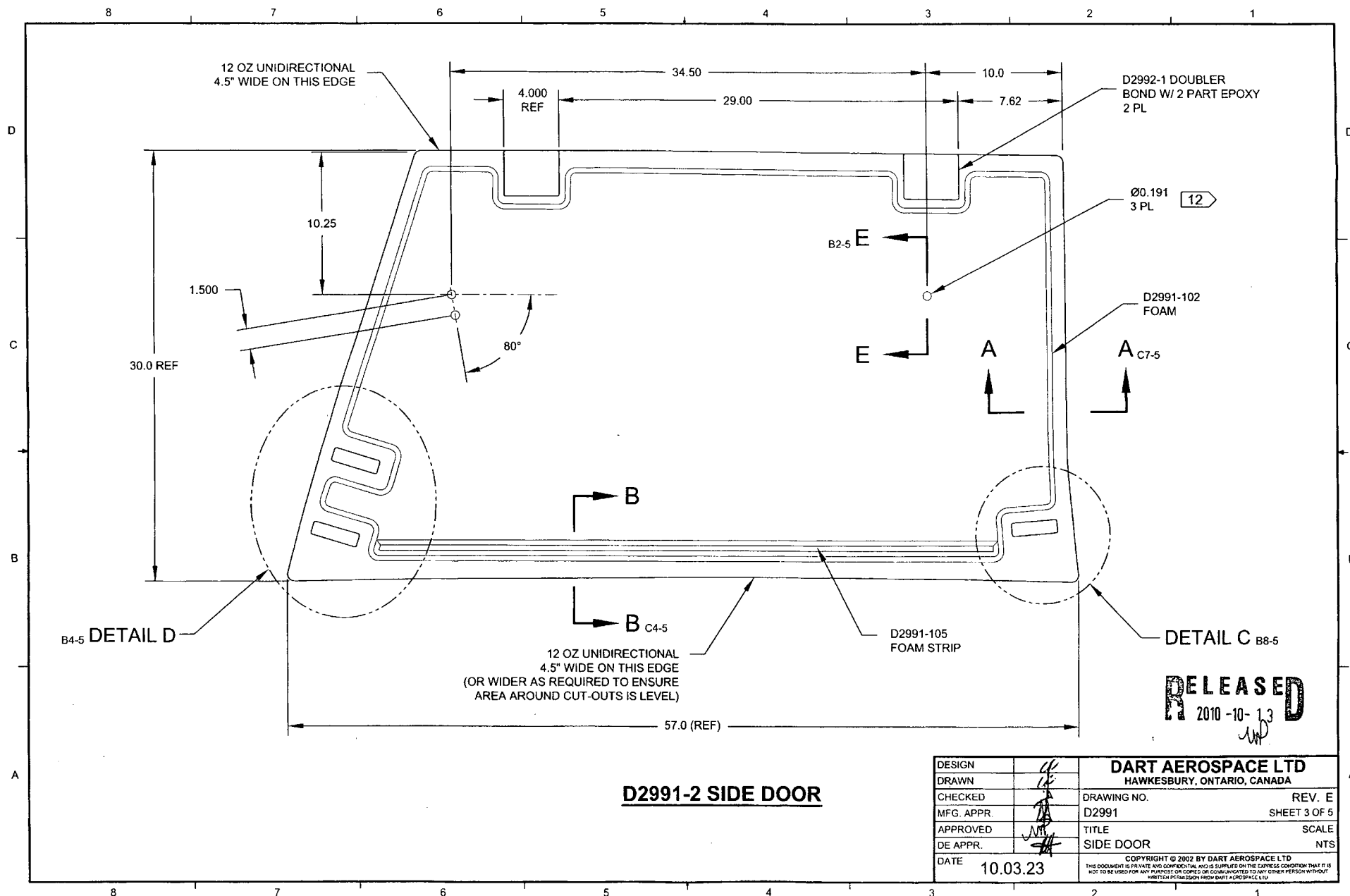
130137 MJS
1502-24

RELEASED
2010-10-13

E	REFORMAT, MOVE HOLE: 16.5 WAS 10.25 (ZN C8-2) 10.7 WAS 10.2 (ZN D7-2), PAR 10-007	CP	10.03.23
D	REFORMAT DWG, ADD DIMS TO DOUBLERS (ZN D7-2, D3-3, D7-4), X.X TOL WAS X.XX (ZN D7-2, D3-3, D7-4, A8-5, A4-5), D2992-1 NOW 4.000 WIDE (ZN D7-2, D5-3, D4-4), RMV DECAL (ZN A8-1), NCR 09-041	CP	09.09.26
C	UPDATE NOTES & MATERIALS; 1.25 WAS 0.50; ADD SECTION E-E; REMOVE D0589-041/-042/-043	MB	07.10.29
B	REMOVE D2621; 5.500 WAS 1.980	RF	02.02.22
A	NEW ISSUE	CP	02.01.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.23		

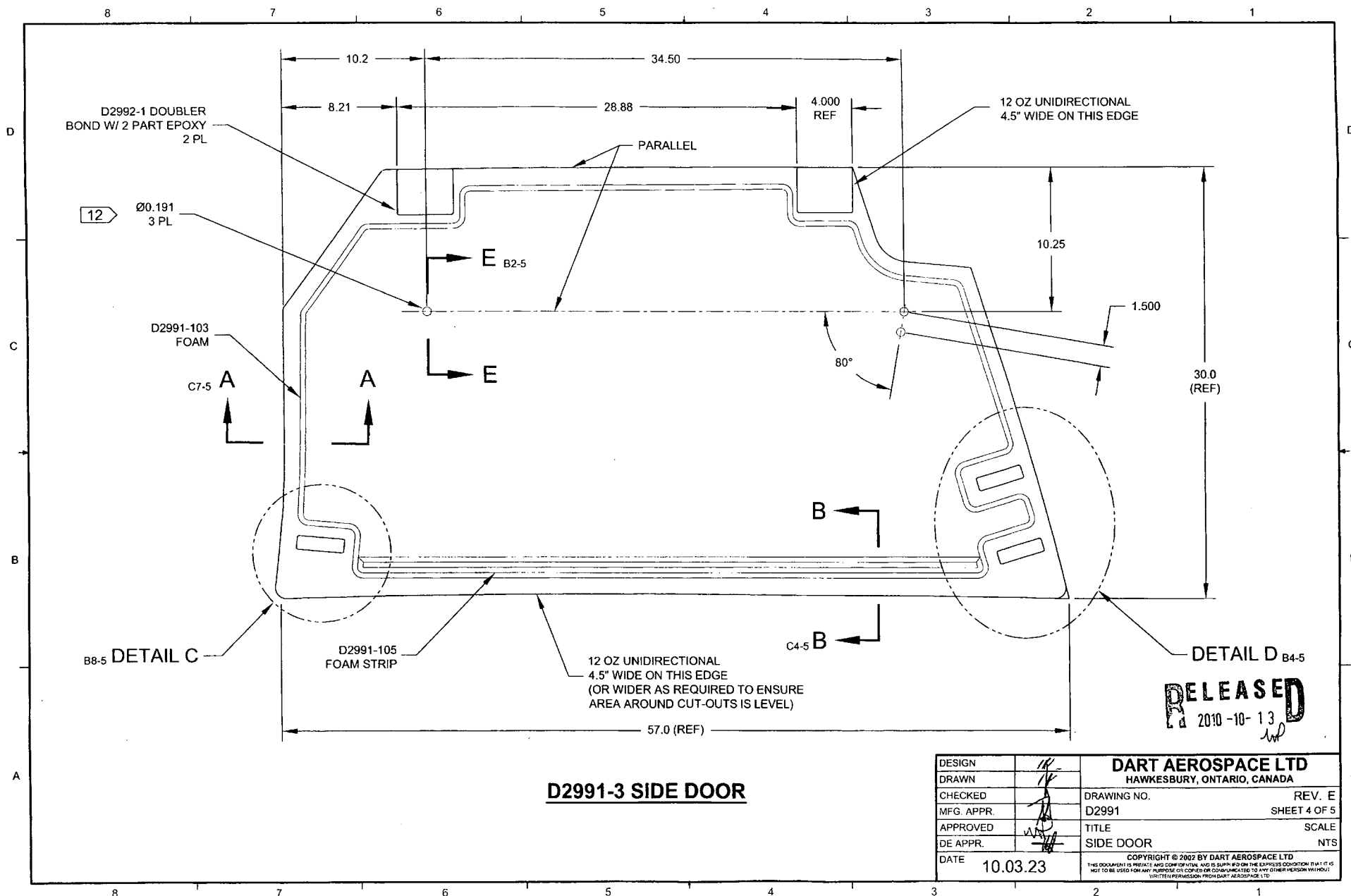
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2991	REV. E SHEET 1 OF 5
TITLE SIDE DOOR	SCALE NTS
COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

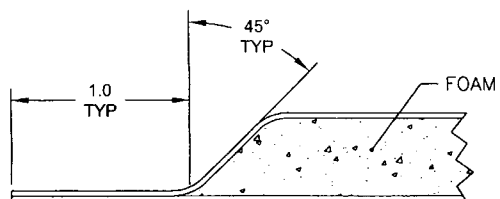




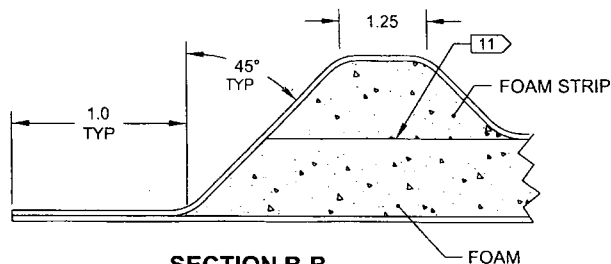
RELEASED
R 2010-10-13
up

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2991	REV. E SHEET 3 OF 5
MFG. APPR.		TITLE SIDE DOOR	SCALE NTS
APPROVED		COPYRIGHT © 2002 BY DART AEROSPACE LTD	
DE APPR.		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	10.03.23		

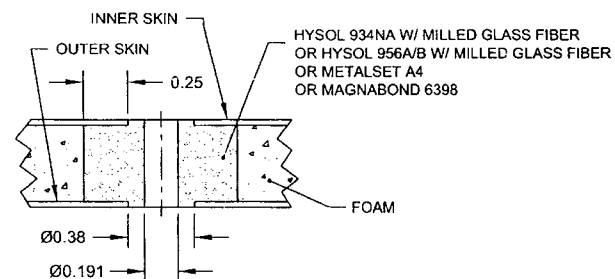




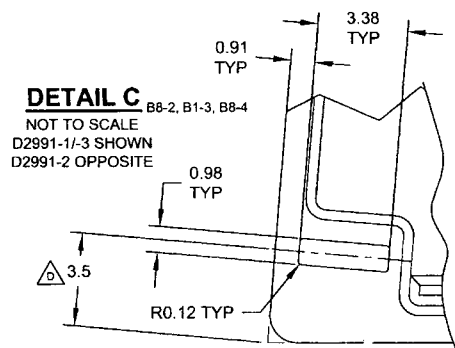
SECTION A-A C7-2, C2-3, C7-4
NOT TO SCALE
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



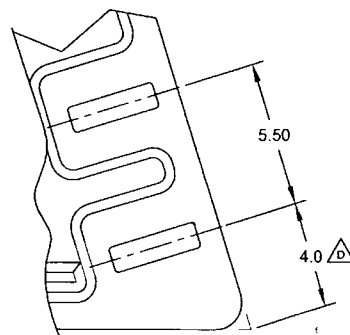
SECTION B-B B4-2, B5-3, B4-4
ONE EDGE ONLY
NOT TO SCALE, VIEW ROTATED
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



SECTION E-E D6-2, D3-3, C6-4
TYPICAL Ø0.191
HOLE DETAIL
NOT TO SCALE



DETAIL C B8-2, B1-3, B8-4
NOT TO SCALE
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



DETAIL D B1-2, B8-3, B1-4
NOT TO SCALE
D2991-1/-3 SHOWN
D2991-2 OPPOSITE

RELEASED
R 2010-10-13
MT

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2991	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SIDE DOOR	NTS
DATE	10.03.23	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27567**

Purchase Order Date 2/25/2015

PO Print Date 2/25/2015

Page Number 1 of 2

Order From :
DELASTEK INC
2699 5E AVENUE, LOCAL C.P 10100

GRAND-MERE, QC G9T 5K7
CA

VU-DEL003

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 819 533 5788

Ship To Contact
Ship To Phone
Ship Via: FedEx Overnight collect
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency USD
FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2991-2P AS PER DWG D2991 REV. E B130137	Side Door	4/24/2015 Yes 4/24/2015		1.00 Each	\$820.00	\$820.00
						Line Total:	\$820.00
2	71401-45	PROCUREMENT QUALITY CLAUSES	4/24/2015 No 4/24/2015		1.00	\$0.00	\$0.00
Procurement Quality Clauses A004 faa-pma/tso A005 right of entry A016 personnel qualification A025 certification of conformance A040 notification of quality escape A041 quality management A042 dart noyification by supplier A043 retention of quality documents							

Note:

2/25/2015

Mastering Innovation

DELASTEK

DELASTEK Inc.
2699 Se Avenue
Local 14,
Grand-Mère, Québec G9T 2P7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice No.	60349
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
18-06-2015	03-03-2015	25589	Chantal Lavoie	PO27567	Net 30 days USA
Ship Via	F.O.D.	Salesperson	GST/PST		
Fedex Int. Eco. Coll.	Point de départ	Melody Shapcott, ext. 235			
Order Qty	D.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC134-0077	Line #1 - Side Door N° D2991-2 Dwg.: D2991 Rév.: E	B130137 Lot # 67938 U of M: Chaque 1

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request

Accepted by:

Mathieu Angèle
Quality department

AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

88/15-06-22

Making Innovation



DELASTEK Inc.
2699 5e Avenue
Local 14,
Grand-Mère, Québec G9T 2P7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice No.	60349
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
18-06-2015	03-03-2015	25589	Chantal Lavoie	PO27567	Net 30 days USA
Ship Via	F.O.B.	Salesperson	GST/PST		
Fedex Int. Eco. Coll.	Point de départ	Melody Shapcott, ext. 235			
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC134-0077	Line #1 Side Door N° D2991-2 B130137 Dwg.: D2991 Rév.: E Lot # 67938	U of M: Chaque 1

7738-6073-3014

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

M. Lavoie
Quality department
AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.



Date: Jeudi, 2015-03-12 13:49:24
Utilisateur: Véronique Bouchard

Feuille de Procédé

Client : DART US DART AEROSPACE LTD	Nom Dessin : SIDE DOOR N. D2991-2
Numéro Job : 67938	Numéro Article : DKC134-0077
Numéro Soumission : 4361	Numéro Dessin : D2991
Numéro B.A. :	Projet Numéro : DK-362
Cette fois : 2015-03-12 No. B.V. :	Révision dessin : E
Prsht Rev. : NC	Matériel : Composites
Prem. fois : - - Type :	Date Dûe : 2015-06-15 Qté: 1 UdM: UNITE
Job précédente : 60290	
Écrit par :	
Vérifié & Approuvé par :	
Commentaires : N. de pièce: D2991-2	

E.O.: N/A

Feuille de Procédé Rév.: 03 changer foam DKC134-0063 pour
DKC134-0083 (réf. RFC #0008)

Formulaire d'inspection: N/A

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

1.0	AAC1616	N° 83634, Frekote Loctite Wolo
-----	---------	--------------------------------

Commentair Qty.: 0.025 UNITE(s)/Unit **Total :** 0.025 UNITE(s)

N° 83634, Frekote Loctite Wolo

de Lot: N/A

2.0 PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 5.0000Min **Total Run :** 0.0833Hrs

Faire la préparation du moule N° DKC-0095 laisser sécher pendant 3 heures selon le QSI-006 et IG 0009.

Date: 23-03-15 Sceau:

3.0 AMB0350

Gel Coat Blanc N° Gel 944W005

Commentair Qty.: 1.200 KILOGRAMME(s)/Unit **Total :** 1.200 KILOGRAMME(s)

Gel Coat Blanc N° Gel 944W005

N° de Lot: 4907730 AA

4.0 AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0045 GALLON(s)/Unit **Total :** 0.0045 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-27829-1

5.0 PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 15.0000Min **Total Run :** 0.2500Hrs

Faire la préparation et l'application du Gel coat selon IG 0019.

Date: 23-03-15 Sceau:

Date: Jeudi, 2015-03-12 13:49:24
Utilisateur: Véronique Bouchard

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 67938

Nom Dessin: SIDE DOOR N. D2991-2
Numéro Article: DKC134-0077

Numéro Job:



Séq.: Machine ou Opération: Description :

6.0 AAC1885 Tissu à délaminer Release ply B

Commentair Qty.: 4.00 VERGE(s)/Unit Total : 4.00 VERGE(s)

Tissu à délaminer Release ply B

de Lot: N/A

7.0 AAC1887

Wrightlon 5200 Bleu P3

Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)

Wrightlon 5200 Bleu P3

de Lot: N/A

8.0 AC0885

Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)

9.0 AC0943

Stretchlon 200 poche à vide Vert

Commentair Qty.: 18.00 PIED(s)/Unit Total : 18.00 PIED(s)

10.0 AMB0214

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentair Qty.: 7.30 VERGE(s)/Unit Total : 7.30 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-46918-1

11.0 AMB0511

N° TG-13-U, Fiberglass 13 oz

Commentair Qty.: 4.00 VERGE(s)/Unit Total : 4.00 VERGE(s)

N° TG-13-U, Fiberglass 13 oz

N° de Lot: 1-46418-1 RL 1-30302-1

12.0 AC0886

Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.0000 ROULEAU(s)/Unit Total : 2.0000 ROULEAU(s)

13.0 PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Tailler le matériel, selon les différents patrons de découpe comme suit:

4 plis de tissus de 9.7 oz.

1 pli de 13 oz. pour tout le contour de la pièce par 5" de large.

3 fois le sac à vide Stretchlon 200.

3 fois le film perforé P-3

3 fois le feutre de drainage

2 fois le tissu à délaminer (non nécessaire lors du bagging du core).

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres.

Date: 23-03-15 Sceau:



Date: Jeudi, 2015-03-12 13:49:24

Utilisateur: Véronique Bouchard

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SIDE DOOR N. D2991-2

Numéro Job: 67938

Numéro Article: DKC134-0077

Numéro Job:



Séq.:

Machine ou Opération:

Description:

14.0 AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.400 KILOGRAMME(s)/Unit Total: 0.400 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 4991910AA

15.0 AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0020 GALLON(s)/Unit Total: 0.0020 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 4965010AA

16.0

PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350

Date: 23-03-15 Sceau:



17.0

LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire le laminage selon IF134-0009.

Date: 23-03-15 Sceau:



18.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Installer la poche à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Curing début: 24/5 Curing Fin: 0.00 AM

Date: 23-03-15 Sceau:



19.0

AAC1611

Polybond B46F

Commentair Qty.: 0.062 KIT(s)/Unit Total: 0.062 KIT(s)

Polybond B46F

N° de Lot: 1-44904-1

Date: Jeudi, 2015-03-12 13:49:24
Utilisateur: Véronique Bouchard

Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: SIDE DOOR N. D2991-2	
Numéro Job: 67938		Numéro Article: DKC134-0077	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
20.0	DKC134-0083	Foam Core N° D2991-102(Porte D2991-2)	
Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) Foam Core N° D2991-102(Porte D2991-2) N° de Job: _____			
21.0	ASSEMBLAGE	Assemblage mécanique	
			
Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs			
Retirez le bagging.			
Sceller le Foam Core principal et la Strip de Foamcore selon IG 0105.			
Coller la "Strip" de foamcore sur le foamcore principal à l'aide de résine 411-350 et DDM-9 selon le dessin.			
Coller l'assemblage des foamcores selon IF134-0009 et IG 0033.			
Date: <u>24-03-15</u> Sceau: 			
22.0	BAGGING	Faire le bagging sur la pièce	
			
Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs			
Faire la poche à vide selon IG 0012			
Laisser sécher pendant 2 heures minimum.			
Curing Début: <u>9.00</u> Curing Fin: <u>8.00</u>			
Date: <u>24-03-15</u> Sceau: 			
23.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Commentair Qty.: 0.400 KILOGRAMME(s)/Unit Total : 0.400 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1991910AA</u>			
24.0	AMB0286	Catalyst N° DDM-9	
Commentair Qty.: 0.0020 GALLON(s)/Unit Total : 0.0020 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>			
25.0	PREP-GENERAL	Préparation du matériel	
			
Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs			
Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.			
Date: <u>25-03-15</u> Sceau: 			

Date: Jeudi, 2015-03-12 13:49:24
Utilisateur: Véronique Bouchard

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 67938

Nom Dessin: SIDE DOOR N. D2991-2
Numéro Article: DKC134-0077

Numéro Job:



Séq.:

Machine ou Opération:

Description :

26.0

LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire le 2ieme laminage des tissus de verre de 9.7 oz et 13 oz. selon IF134-0009.

Date: 25-03-15

Sceau:



27.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Curing Début: 9.45 Curing Fin: 8.00

Date: 25-03-15

Sceau:



28.0

DÉMOULAGE

Démoulage



Commentair Setup: 0.00Hrs/ Run: 5.0000Hrs Total Run : 5.0000Hrs

Démouler la pièce en faisant bien attention de ne pas abimer les coins et les rebords.

Date: 25-03-15

Sceau:



29.0

TRIMAGE

Trimage



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Tailler le contour de la pièce à la main aux dimensions du dessin en utilisant un router muni d'un couteau 1/2 diamant.

Date: 26-03-15

Sceau:



30.0

AAC0205

N° EA934NA, Adhesive Hysol

Commentair Qty.: 0.15 KIT(s)/Unit Total: 0.15 KIT(s)

COLLE HYSOL EA934NA

N° de Lot: 15651-2

Date: Jeudi, 2015-03-12 13:49:24
Utilisateur: Véronique Bouchard

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 67938

Nom Dessin: SIDE DOOR N. D2991-2
Numéro Article: DKC134-0077

Numéro Job:



Séq.: Machine ou Opération: Description :

31.0 AAC1540 Fibre de verre Miapoxy 66

Commentair Qty.: 0.0037 GALLON(s)/Unit Total: 0.0037 GALLON(s)

Fibre de verre Miapoxy 66

N° de Lot:

1-44138-3

32.0 TRIMAGE Trimage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide du Gabarit N°DKO-0119, percer les 3 trous de .191" selon IF134-0010.

Laisser sécher jusqu'au lendemain.

Date: 26-03-15 Sceau:



33.0 AAC1492 N° P-15-3, Adtech Micro Ultra Filler

Commentair Qty.: 0.010 GALLON(s)/Unit Total: 0.010 GALLON(s)

N° P-15-3, Adtech Micro Ultra Filler

de Lot:

4808910 AA

34.0 AAC0102 Colle Araldite N° 2012 (50ml)

Commentair Qty.: 0.10 UNITE(s)/Unit Total: 0.10 UNITE(s)

Colle Araldite N° 2012 (50ml)

N° de Lot:

4829510 AA

35.0 AAC1768 N° D2992-1, Doubler

Commentair Qty.: 2 UNITE(s)/Unit Total: 2 UNITE(s)

N° D2992-1, Doubler

N° de Lot:

5031110 AA

36.0 ASSEMBLAGE Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide de l'adhésif ARALDITE, assembler les "Doubler" sur la pièce de composite selon le dessin.

Sceller le contour des "Doubler" à l'aide de "Putty".

Date: Sceau:

37.0 AAC1021 Dupont Primer N° 7704S

Commentair Qty.: 0.1800 UNITE(s)/Unit Total: 0.1800 UNITE(s)

Dupont Primer N° 7704S

N° de Lot:

38.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.1800 UNITE(s)/Unit Total: 0.1800 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot:

Date: Jeudi, 2015-03-12 13:49:24
Utilisateur: Véronique Bouchard

Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: SIDE DOOR N. D2991-2	
Numéro Job: 67938		Numéro Article: DKC134-0077	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
39.0	PRÉPARATION	Préparation du matériel	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs			
Préparer la pièce selon IG 0008.			
Quantité: <u>1</u> Date: <u>11-06</u> Sceau: <u>4424</u>			
40.0	PRIMER	Application primer	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Préparer et appliquer le primer selon I.G. 0008.			
Date: <u>11-06</u> Sceau: <u>4424</u> # de fiche de mélange: <u>10663</u>			
41.0	FINITION	Finition Générale	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Poncer le "Primer" batisseur selon IG 0008.			
Quantité: <u>1</u> Date: <u>12/06/15</u> Sceau: <u>4254 ml</u>			
42.0	AAC1021	Dupont Primer N° 7704S	
Commentair Qty.: 0.2000 UNITE(s)/Unit Total : 0.2000 UNITE(s)			
Dupont Primer N° 7704S N° de Lot: <u>4768450AA</u>			
43.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
Commentair Qty.: 0.2000 UNITE(s)/Unit Total : 0.2000 UNITE(s)			
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: <u>1740542-1</u>			
44.0	PRIMER	Application primer	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Préparer et appliquer le primer selon IG 0008.			
Quantité: <u>1</u> Date: <u>12-06</u> Sceau: <u>4424</u>			
45.0	INSPEC FINAL	Inspection finale	
			
Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs			
Faire l'inspection selon le dessin N° D2991.			

Date: Jeudi, 2015-03-12 13:49:24
Utilisateur: Véronique Bouchard

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 67938

Nom Dessin: SIDE DOOR N. D2991-2
Numéro Article: DKC134-0077

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Date: 15/06/15 Sceau:



46.0

EMBAL / ENTREPO

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire l'emballage et entreposage selon IG 0057.

Date: 15/06/15 Sceau:

